

Date: Wednesday, 7/11/2007 2:46:15 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	LID PRO ARM ASSEMBLY (SHORT)		
Job Number	33467	Part Number	D2332041		
Estimate Number	10258	Drawing Number	D2332 REV C1		
P.O. Number	N/A	Project Number	N/A		
This Issue	7/11/2007	S.O. No.	N/A		
Prsht Rev.	NC	Type	SMALL /MED FAB		
First Issue	N/A	Material	N/A		
Previous Run	32572	Due Date	7/30/2007		
Written By		Qty:	20	Um:	Each
Checked & Approved By					
Comment	Est: B 02/06/12 Re-format; Incorporated D2332-13/-11/-7/-5 K J/RF				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:	
1.0	M304TR1000WO49	304 RD Tube 1.0" x .049W	
		Comment: Qty.: 0.4331 f(s)/Unit Total : 8.6625 f(s) Material: 1.000" OD x 0.049" wall SS Tube (Seamless)	 Batch: M103849 ② M105260 ③
2.0	M304R250	1/4" 304 SS Roundbar	
		Comment: Qty.: 0.1092 f(s)/Unit Total : 2.1840 f(s) Material: Ø0.250" 304SS Rod	 Batch: M105950 ② M14686 ③
3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
		Comment: SMALL & MEDIUM FAB RESOURCE 1	 1-Cut to length as per Dwg D2332 (D2332-7) Locking Collar → M105950 ② Dm 07/16/22 ③ 2-Cut to length as per Dwg D2332 (D2332-5) Stop Pin → M105950 ② Dm 07/09/17 ③ 3-Deburr → M105950 ② Dm 07/09/17 ③
4.0	M304TR0500W035	304 RD Tube .500 x .035W	
			 Comment: Qty.: 1.2502 f(s)/Unit Total : 25.0040 f(s) 304 RD Tube .500 x .035W M104880 ② M104862 ③

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LID PRO ARM ASSEMBLY (SHORT)

Job Number: 33467

Part Number: D2332041

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 BRAKE NC NC BRAKE



Comment: NC BRAKE

Punch or form to length as per Dwg D2332 (D2332-11) using DT8012

(Note: Make (2) D2332-11 Prop Arms per assembly.)

FF 07-08-16

6.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

~~M105524~~

1-Drill hole in D2332-11 as per Dwg D2332 using Drill Jig DT8459. Deburr. (Drill 1 per assembly)

→ ~~M105524~~ 07/09/08

2-Weld D2332-11 and D2332-5 as per Dwg D2332 using Welding Jig DT8298. (Weld 1 per assembly)

~~M105524/M105950~~ 07/11/08

A/R SS Rod Batch: ~~M105524/M105950/M105524~~ M105524

07/11/08

7.0 QC9 VISUAL WELDING INSPECTION



F.C.

Comment: VISUAL WELDING INSPECTION

PD 07-11-05 (20)

8.0 QC5 INSPECT WORK TO CURRENT STEP



counted

Comment: INSPECT WORK TO CURRENT STEP

07/11/05

(20)

9.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

07/11/05

(20)

1-Tumble

07/11/05

(20)

2-Assemble as per Dwg D2332

07/11/12

(20)

10.0

AN44A

Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN4-4A

Bolt

1101291

BB/07/11/12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2332-041 PAR #: Fault Category: Prod Fns. Ass ^{med & small} NCR: Yes No DQA: D Date: 07/11/15
QA: N/C Closed: X Date: 07.11.15

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LID PRO ARM ASSEMBLY (SHORT)

Job Number: 33467

Part Number: D2332041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0 AN960JD416L Washer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

X

Qty Part Number Description

3 AN960JD416L Washer

Batch

1105408



7/11/12

12.0 MS21042L4 Nut



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)

Pick:

Qty Part Number Description

1 MS21042L4 Nut (or -4)

Batch

1105054



7/11/12

13.0 QC5 INSPECT WORK TO CURRENT STEP



INSPECT WORK TO CURRENT STEP

7/11/14 (20)



Comment: INSPECT WORK TO CURRENT STEP

14.0 PACKAGING 1 PACKAGING RESOURCE #1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *ST 203*

LL AS 07/11/15

(20)

15.0 QC21 FINAL INSPECTION/W/O RELEASE



FINAL INSPECTION/W/O RELEASE



7/11/15

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



LL 07.11.15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

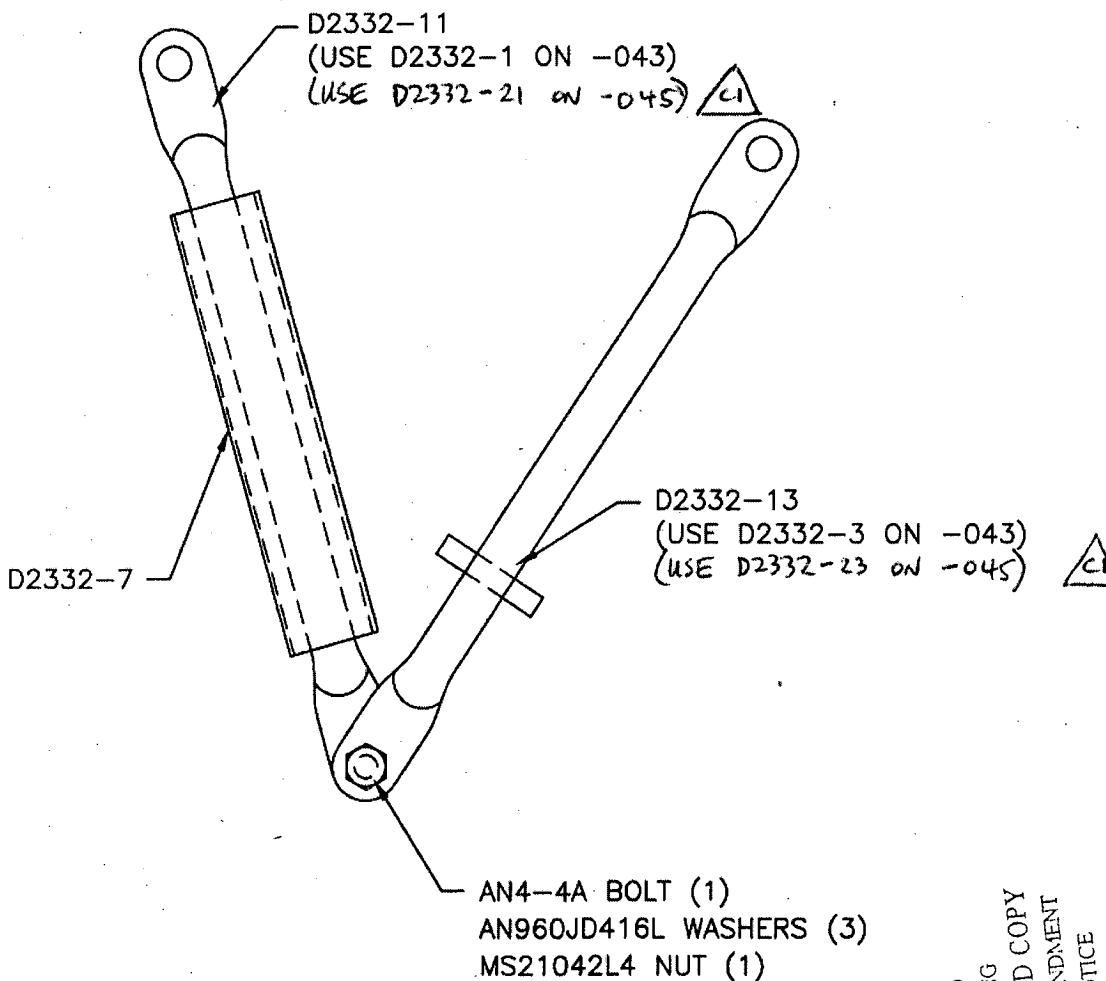
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

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DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2332	SHEET 1 OF 2
DATE		TITLE	SCALE
03.07.03		LOD PROP ASSEMBLY	NTS
A	94.12.16	NEW ISSUE	
B	97.09.30	CHANGE 416 WASHERS TO 416L	
C	03.07.03	MAKE -041 PROP 6.69" LONG (STD) MAKE -043 PROP 8.00" LONG (OPT.)	
C1	03.08.06	ADD -045 PROP (7.25" LONG)	

RELEASED
03.07.04

D2332-041 SHOWN
(D2332-043 SIMILAR)
(D2332-045 SIMILAR)

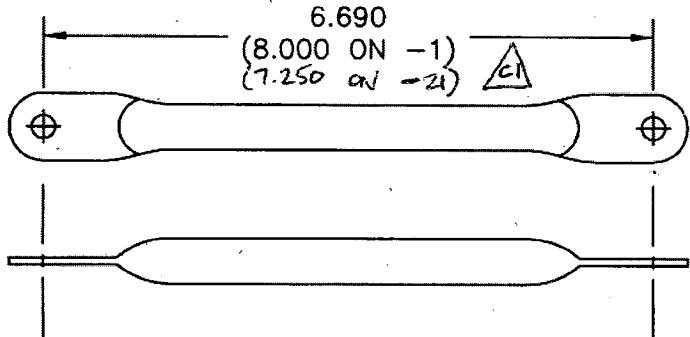
C1

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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33467

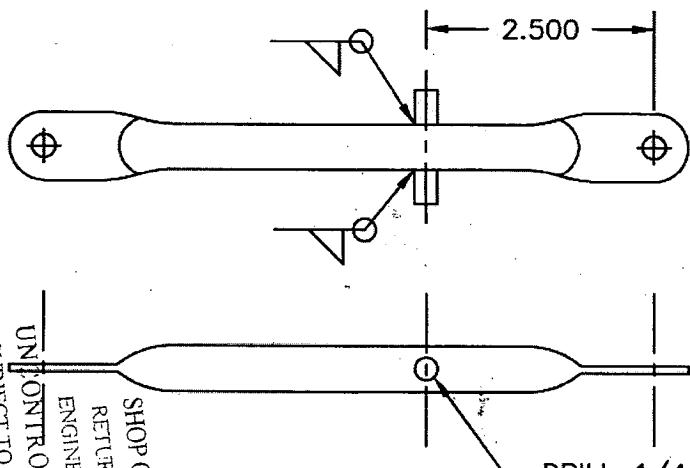
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RELEASED
03.07.94

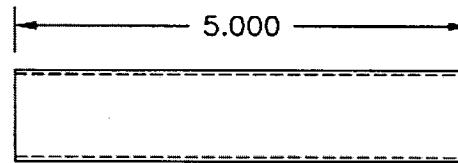


D2332-11 PROP
(D2332-1 SIMILAR)

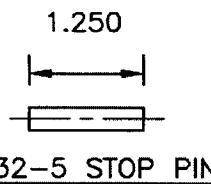


D2332-13
M/F D2332-11 & D2332-5

D2332-3 SIMILAR - M/F D2332-1 & D2332-5
(D2332-23 SIMILAR - M/F D2332-21 & D2332-5)



D2332-7 LOCKING COLLAR



D2332-5 STOP PIN

DART

6 COPY ISSUED

CHECKED APPROVED

DATE 03.07.03

TITLE LID PROP ASSEMBLY

DESIGN # DRAWN BY

DRAWING NO. D2332

REV. C

SHEET 2 OF 2

DATE	TITLE	SCALE
C	MALE -041 Prop 6.69" long (4in) MALE -043 Prop 8.00" long (6in)	1:2
C1	ADD -045 Pin (1.25" long)	

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NO. 33467

NOTES:

1. MATERIAL: 0.5 OD x 0.035 WALL SS TUBE (D2332-1/-11) M304TR0.500W.035
0.25 OD SS ROD 1.25 LONG (D2332-5) M303R0.250
1.0 OD x 0.049 WALL SS TUBE (D2332-7) M304TR1.000W.049
2. TUBE ENDS ARE CENTER-CENTER FOR D2332-1/-3 & D2332-11/-13

